



Installing the Secondary Cylinder

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TOOLS:

- [Welder \(1\)](#)
- [hole puncher \(1\)](#)
- [various wrenches \(1\)](#)



PARTS:

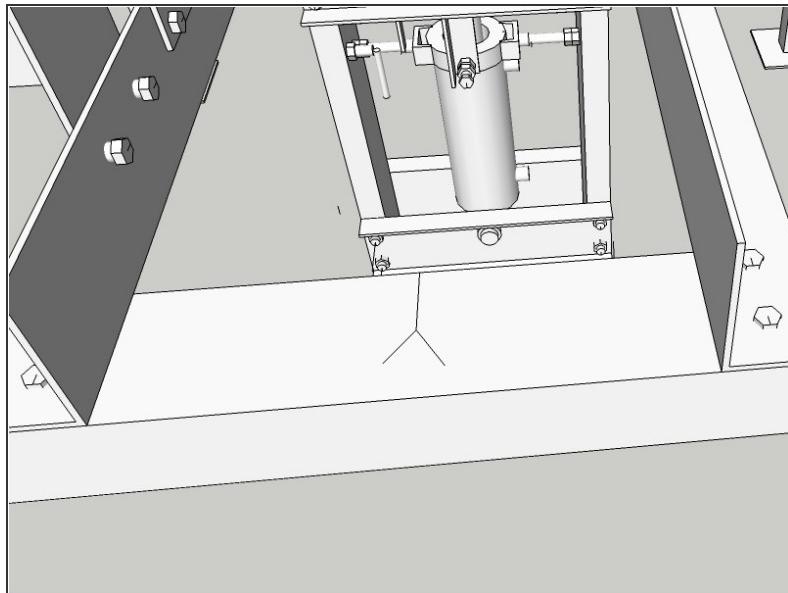
- [1/2"x3"x3" steel plate \(1\)](#)
- [1" washers \(2\)](#)
- [Secondary Cylinder \(1\)](#)

- [Secondary cylinder hose unit \(1\)](#)

See

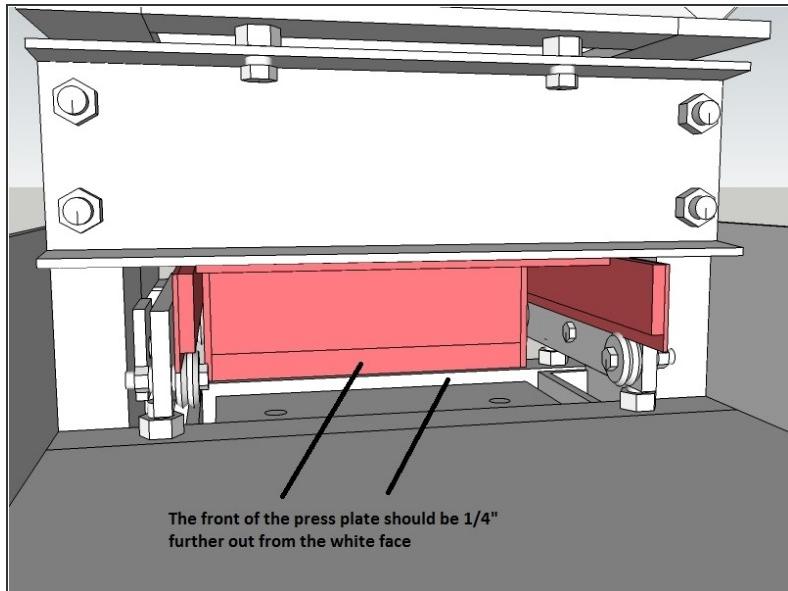
[\[http://opensourceecology.org/wiki/CEB_Press/Manufacturing_Instructions/Hoses - Secondary_cylinder_hose_unit/Secondary_Cylinder_Hose_Unit\]\]](http://opensourceecology.org/wiki/CEB_Press/Manufacturing_Instructions/Hoses - Secondary_cylinder_hose_unit/Secondary_Cylinder_Hose_Unit)

Step 1 — Mark the center between the primary arms on the secondary arm.



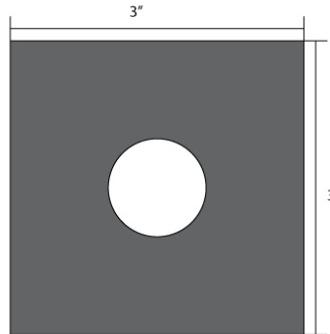
- This is on the opposite side of the CEB of the brickholder plate.

Step 2 — Position the drawer



- The drawer needs to be in the fully retracted position.
- This is when the drawer is about to eject the brick, the press plate will be back $1/4"$ from the inside of the compression chamber.

Step 3 — Prepare the cylinder mount.



1/2" Thick steel with 1" hole punched in center.

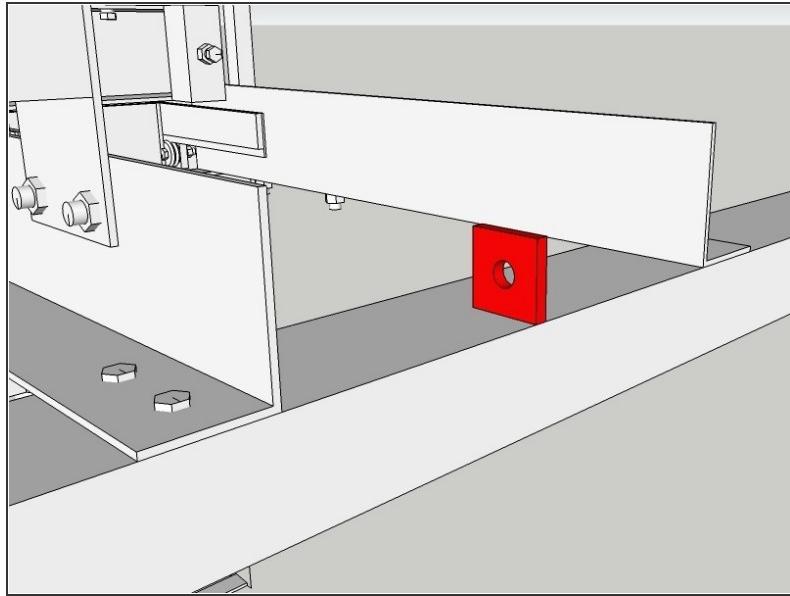
- Punch a 1" hole in the center of a 3"x3" piece of 1/2" thick steel.

Step 4 — Place the cylinder



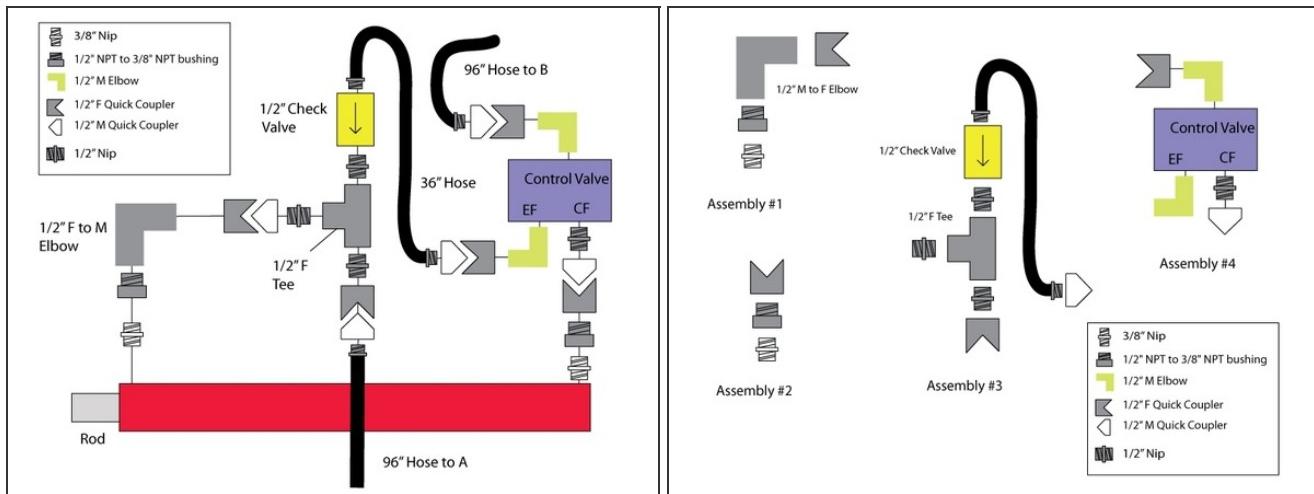
- On the side which attaches to the secondary arm, put the pin through the mount, a 1" washer, and the cylinder.
- The side of the cylinder with the rod attaches to the drawer.
 - Both sides will need a 1" washer to act as a spacer so the cylinder can't slide back and forth.
- When the cylinder is attached to the drawer, place the mount on your center mark.
- Square the mount in all directions.

Step 5 — Weld the mount in place



- Tack the mount in a few places.
- Remove the pin and move the cylinder out of the way of the mount.
- You can slide the drawer away so you don't need to remove that side.
- Weld the mount solid, all the way around. Make sure it stays square.

Step 6 — Install hoses



- Return the secondary cylinder and re-mount it. Don't forget the washer.
- Remove the plug from the port on top of the cylinder.
 - The cylinder may have fluid in it, so keep a jar handy to catch any that spills.
- Install Assembly #2 into this port.
- Couple the remaining assemblies and hoses in place.

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